

DART AEROSPACE LTD		Work Order:	23012
Description: Fitting		Part Number:	D3299-3
Dwg: D3299 Rev. A1 <i>04.11.16</i>		Qty:	10 13
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>JA</i>	05.04.13	10
2	MC	Machine as per Folio FA452 and Dwg D3299 Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.00" Hex (M6061T6H1.000) Identify as D3299-3 Batch: <i>M17029</i>	<i>JG</i>	05/05/05	14
3	QC2	Inspect parts as they come off the CNC machine	<i>JG</i>	05/05/05	14
4	QC8	Second check	<i>gml</i>	05/05/05	14
5	MC	Deburr	<i>JG</i>	05/05/05	14
6	PG	Issue P/O: <i>2008103</i> Anodize as per Dwg D3299 Possible Supplier: TNM Paint Material release note is required	<i>U</i>	05.05.06	14
7	RG	Receive and Inspect for transit damage Ensure material release note is attached	<i>CL</i>	05/05/12	13
8	QC5	Inspect work to Step 7	<i>2</i>	05-05-12	13
9	ST	Identify and Stock <i>Identify with paint & Batch # with a fine point marker</i>	<i>CL</i>	05/05/12	13
10	AC	Cost / part: <i>20.48</i>	<i>AL</i>	05/05/13	B
11	DC	Close W/O <i>20.48</i> Inspect Level 21	<i>JA</i>	05.05.16	13

RF took
one

Rev	Date	Change	Revised By	Approved
A	04.10.04	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
04.10.04

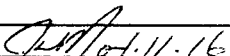
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____


DART AEROSPACE LTD		Work Order:	23012
Description: Fitting		Part Number:	D3299-3
Inspection Dwg: D3299	Rev: A	 04.11.16	
			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.001	✓			
Ø0.302	+0.005/-0.000	0.302	✓			
0.550	+/-0.010	0.559	✓			
0.63	+/-0.030	0.618	✓			
2.08	+/-0.030	2.080	✓			
0.900		0.900	✓			
53°		53°	✓			
0.476	+0.005/-0.000	0.476	✓			
MOW for 9/16"-18	Min = 0.5653 Max = 0.573	0.571	✓			
0.200	+/-0.030	0.190	✓			
0.450	+/-0.010	0.458	✓			
0.10	+/-0.030	0.105	✓			
Length of Engagement for 1/4 NPT 0.227	+/-0.010	0.237	✓			

Measured by:	SG	Audited by:	me	Prototype Approval:	N/A
Date:	05/05/05	Date:	05/05/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.17	New Issue	KJ/JLM	

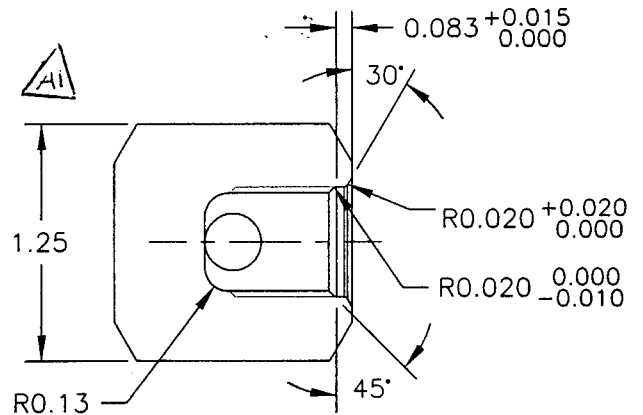
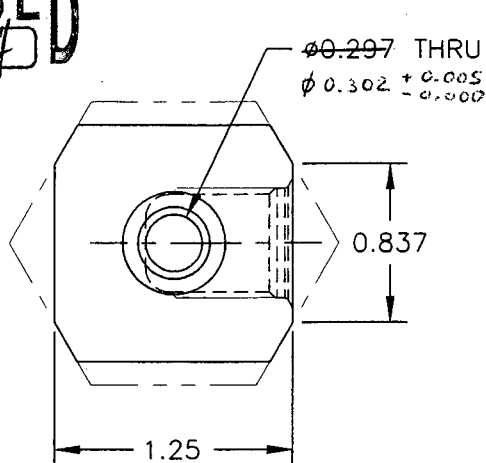
RELEASED

04/04/10

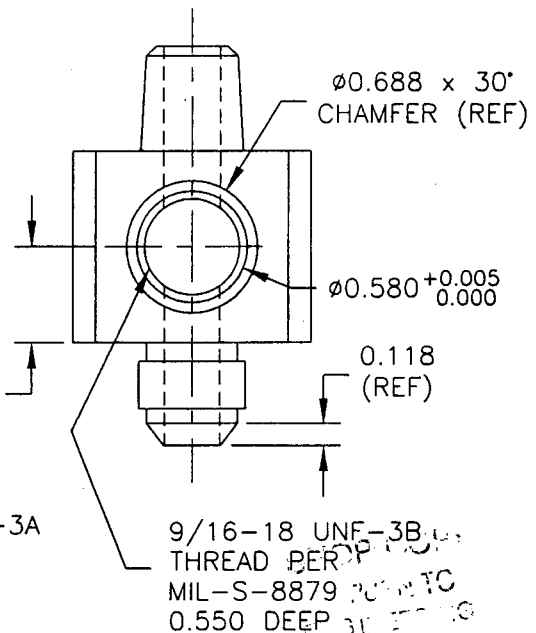
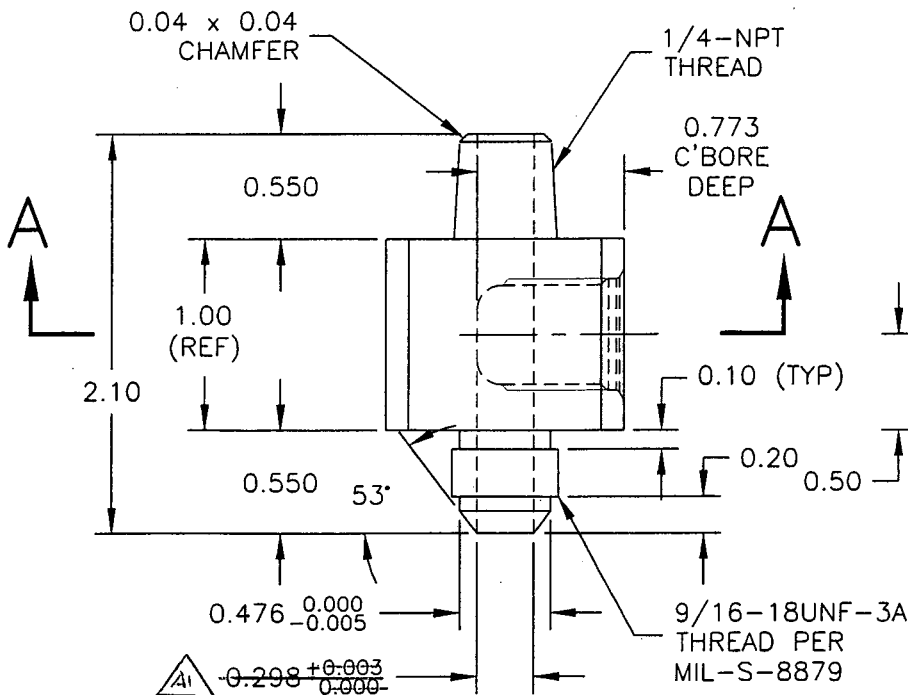


DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3299	REV. A SHEET 1 OF 3
DATE 04.07.06	TITLE FITTING	SCALE 1:1	
A	04.07.06	NEW ISSUE	
A1	04.11.15	Ø0.302 WAS Ø0.297; ADD Ø0.540; R0.13	

RELEASED
04.09.09



SECTION A-A



D3299-1

D3299-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625) - DIMEN.
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 NOTICE
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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WITH NOTICE

WORK ORDER
NO. 23012

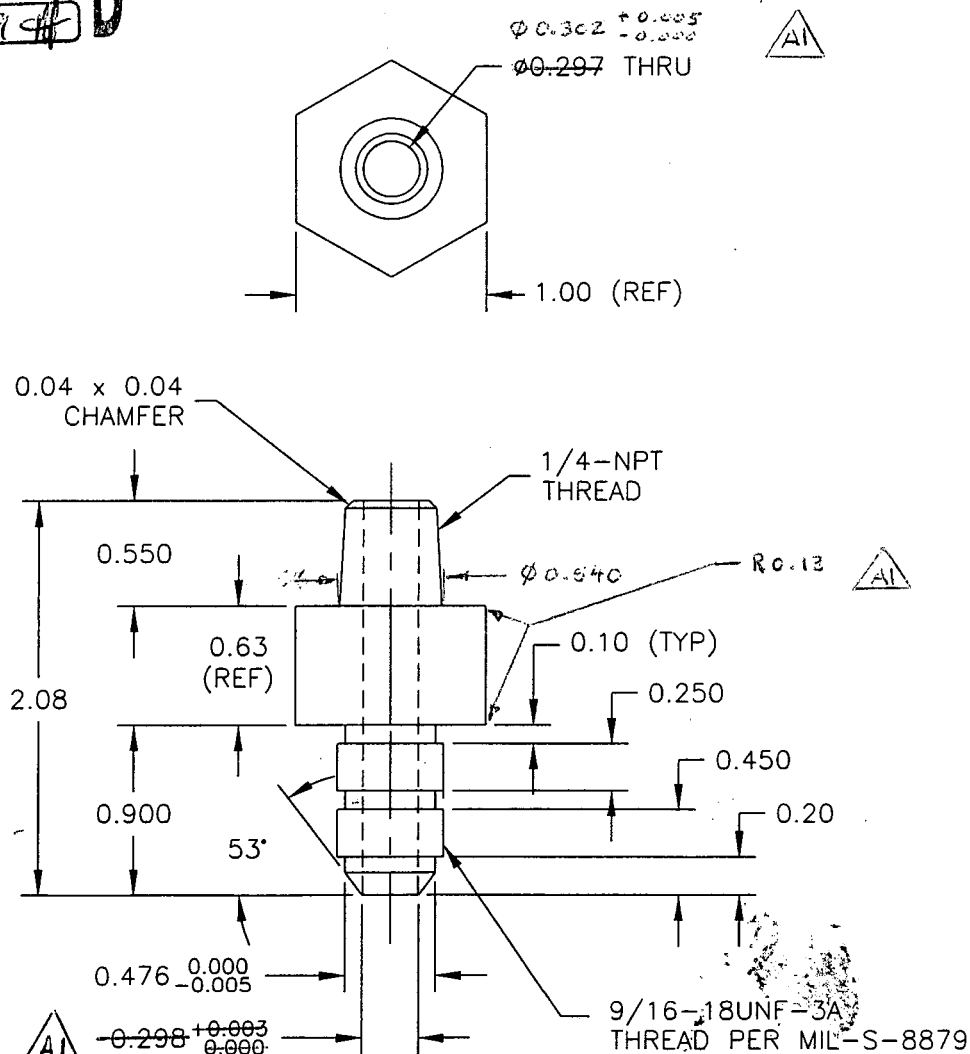
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DESIGN <i>RT</i>	DRAWN BY <i>RT</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D3299	REV. A SHEET 2 OF 3
DATE 04.07.06		TITLE FITTING	SCALE 1:1

RELEASED
04.09.04 *CH*



D3299-3

D3299-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1.000)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB-CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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10/1/00

10/1/00

WORK ORDER

NO. 23012

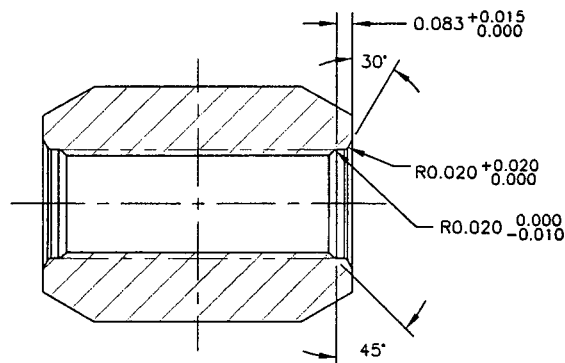
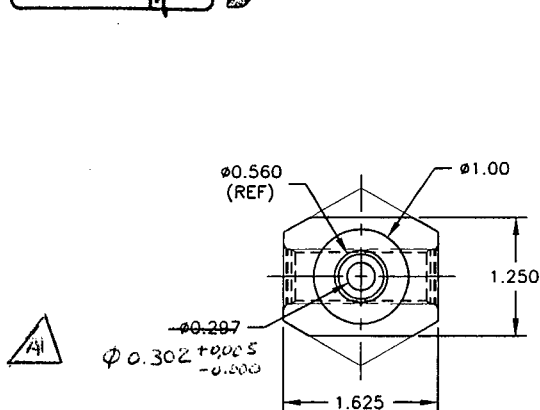
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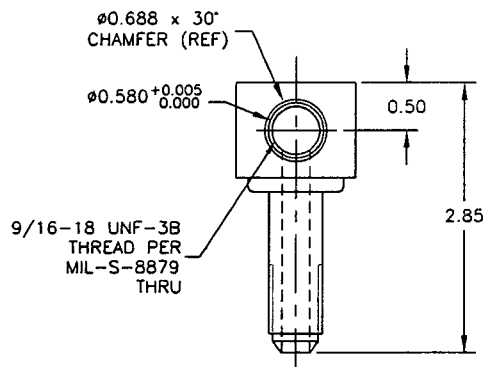
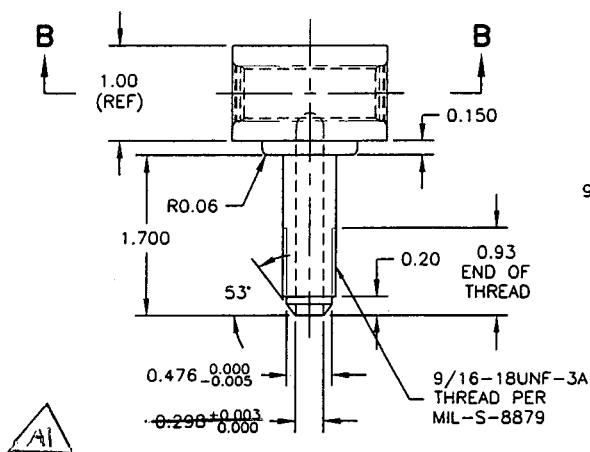


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3299	REV. A SHEET 3 OF 3
DATE 04.07.06		TITLE FITTING	SCALE 1:2

RELEASED
04.09.04 [Signature]



SECTION B-B
SCALE 1:1



D3299-5

D3299-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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WORK ORDER
NO. 23012

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 12, 2005
02:25 pm

Work Order No : 0023012
Project Name : D3299-3
Project For : WK520
Work Order Type : Main
Main WO Number :
House Part Number : D3299-3
Description : Fitting
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 04-12-05
Est Finish Date : 05-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

TNM**ANODISATION et PEINTURE TNM INC.**

C. OF C

4454 Garand, Ville St. Laurent, QC H4R 2A2
Telephone: (514) 335-7001 Fax: (514) 335-3920
Certifié ISO 9001-2000 / ISO 9001-2000 certified
Certifié NADCAP / NADCAP certified

40916

06-May-2005

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE

PURCHASE ORDER/
NO. DE COMMANDE: 2008003



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	6	6	D3299-1 FITTING	B23012 BLUE ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER
2	13	13	D3299-3 FITTING	B22648 BLUE ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER

Nous certifions que les articles énumérés ont été procédés accordément à l'inspection ci-haut.
Les cartes de travail ont été remplies et sont disponibles pour consultation sur demande.

We hereby certify that the above parts have been processed in accordance with the above inspection.
Travel cards have been filed and are available for viewing upon request.

Signature/Signed: _____

Directeur de la Qualité / Q.A. Manager

